

Date: Wednesday, 3/12/2008 1:51:27 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: PLATE		
Job Number	37886			Part Number	: D32191		
Estimate Number	10425			Drawing Number	: D3219 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	3/12/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	/: /	Type	: SMALL /MED FAB	Due Date	3/24/2008	Qty:	60
Previous Run	: 36861			Um:	Each		
Written By	: <u>11/08/03/12</u>						
Checked & Approved By							
Comment	: Est. A 04.04.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
		 Comment: Qty.: 0.1012 sf(s)/Unit Total : 6.0732 sf(s) 6061-T6 .125 Sheet To be made in multiples of 4 Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: <u>M105646</u>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev: <u>A</u> Prog Rev: <u>A</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <u>11/08/03/14</u>
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 <u>11/08/04/04</u>
		 Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <u>11/08/04/04</u>
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37886		Part Number: D32191
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5 	INSPECT WORK TO CURRENT STEP <i>5 08/04/04 (16) occurs</i>
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 <i>AS 08/04/04 (16)</i>
8.0	QC21 	FINAL INSPECTION/W/O RELEASE <i>08/04/08 J</i>
Comment: INSPECT WORK TO CURRENT STEP		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST266 (Temporary)</i>		
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>W 08/04/04</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37886
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

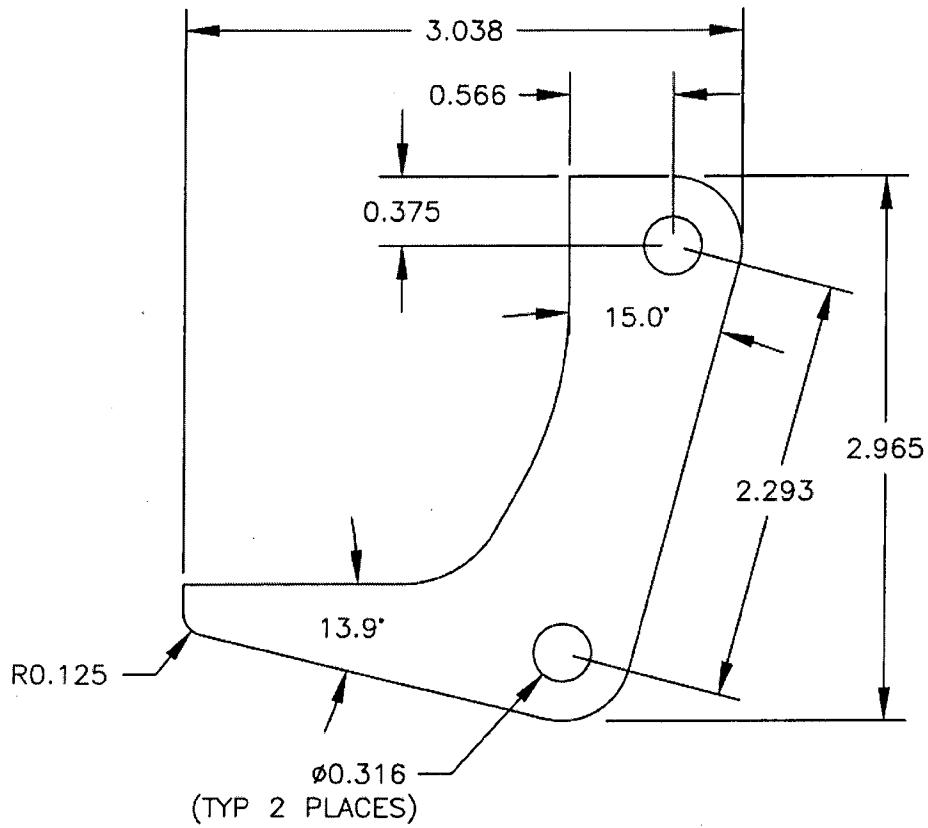
X First Article Prototype

Measured by:	<i>ML</i>	Audited by:	<i>ML</i>	Prototype Approval:	N/A
Date:	08/03/14	Date:	08/04/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	
B	07.09.06	13.9° dimension added	KJ/JLM	EE

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3219	SHEET 1 OF 1
DATE		TITLE	SCALE
03.10.10		PLATE	1:1
A	03.10.10	NEW ISSUE	

RELEASED
 04.04.05


SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 37886

D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES